

Deriv. 57116

Work Order ID 52684-1

October 7, 2009 10:23:36 AM

Split 09/10/20



Page 1

Item ID:	D3180-041	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Strut Assembly					
Start Date:	07/10/2009	Start Qty: 5.00		Cust Item ID:		
Required Date:	15/10/2009	Req'd Qty: 5.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date: 09-10-7	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3180	Rev B								
100	NC BRAKE	0.00							
	Brake NC								
	Brake NC								
	Memo	0.00							
	1-Punch 304/316 Seamless Tubing with 3/4" O.D. x 0.049" wall to length as per Dwg D3180 using DT8313 Ensure rotate and punch one end only as per view B-B as per Dwg. D3180								
110	Small Fab	0.00							
	Small Fab								
	Small Fab								
	Memo	0.00							
	1-Drill Ø0.203" as per Dwg D3180 2-Bend one side only as per Dwg D3180 Identify as D3180-1 3-Deburr edges								
120	QC5- Inspect part completeness to step on W/O	0.00							
	QC								
	Quality Control								
	Memo	0.00							

30 09/10/20

7m-1 09/10/20

28 09/10/20

(5x)

(85)

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Accept

Setup Start

Stop

Cust Item ID:

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start

Stop

**Insp.
Stamp**

0.00

M112260

Memo

START TIME: 8:45am ☐ OVEN TEMPERATURE: 400°F
9:15am ☐ FINISH TIME:

0.00

Memo

0.00

Quality Control

0.00

Memo

1-Assemble as per Dwg D3180

Small Fab

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Item ID: D3180-041

Accept

Revision ID: B

Item Name: Strut Assembly

Start Date: 07/10/2009 Start Qty: 5.00

Required Date: 15/10/2009 Req'd Qty: 5.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 52277

0.00

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

(+2)

10/13/22 (2)

10/03/24
MF
10-3-23

Picklist Print

Page 1

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Work Order ID: 52684

Parent Item: D3180-041RevB

Parent Item Name: Strut Assembly


Comments:

Start Date: 07/10/2009

Required Date: 15/10/2009

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039-1-10		Purchased	No			100	Each	237.0000	5.0000			
												
Screw												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

237

111425

37

112794 ✓

100

112828 ✓

100

A1449

Purchased

No

150

Each

1,214.000 5.0000



Grommet

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

1214

1487

1214 ✓

M112794
M112828

(2x)
(3x)

10/03/16

M-k *

M1487 (5x)

M-k *

10/03/16

Picklist Print

October 7, 2009 10:23:36 AM

Work Order ID: 52684

Parent Item: D3180-041RevB

Parent Item Name: Strut Assembly


Comments:

Start Date: 07/10/2009


Required Date: 15/10/2009

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10 		Purchased	No			150	Each	1,942.000	15.0000			
Washer												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	1942	
105442	95	
109059	2	
109840	23	
110985	202	
111279	5	
111668	64	
112314	1000	
112369 ✓	551	

✓ BLRS-001 	Purchased	No				150	Each	3.0000	5.0000			
Pip Pin												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	3	
104700	2 ✓	
15608	1 ✓	

M113002

M1104700 (2x)
M115608 (1x)

(2x)
m-h w/03/16

Picklist Print

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Work Order ID: 52684

Parent Item: D3180-041RevB

Parent Item Name: Strut Assembly

Start Date: 07/10/2009

Required Date: 15/10/2009

Start Qty: 5.00

Required Qty: 5.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2022-101RevN/A		Manufactured	No			150	Each	591.0000	10.0000			
Spacer												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST504	591	
45885 ✓	391	
50746	100	
52325	100	

m-l
M45885 10/03/16

✓ D2690-6RevB2

Manufactured No



Lanyard Assembly

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	2	
44048	2	
Main Warehouse		
ST41	30	
50665	30	

M44048 (3x)

53112

(2x) m-l
10/03/16

Picklist Print

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Work Order ID: 52684

Parent Item: D3180-041RevB

Parent Item Name: Strut Assembly


Comments:

Start Date: 07/10/2009

Required Date: 15/10/2009

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR0.750W.065 		Purchased	No			150	f	134.8000	18.8595			
304 RD Tube .750 x .065W												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
MAT	134.8	
104565	14.8	
110113	120	

MS21042L3



Nut

Purchased

No

150

Each

3,561.000 5.0000



4 15.0870 *
4.0000
8009/10/21

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	3561	
110844	32	
111274	41	
111668	988	
112314	2000	
112385	500	

111668 (5X) *
m-l
10/03/16

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Shop Packet Print

Page 4

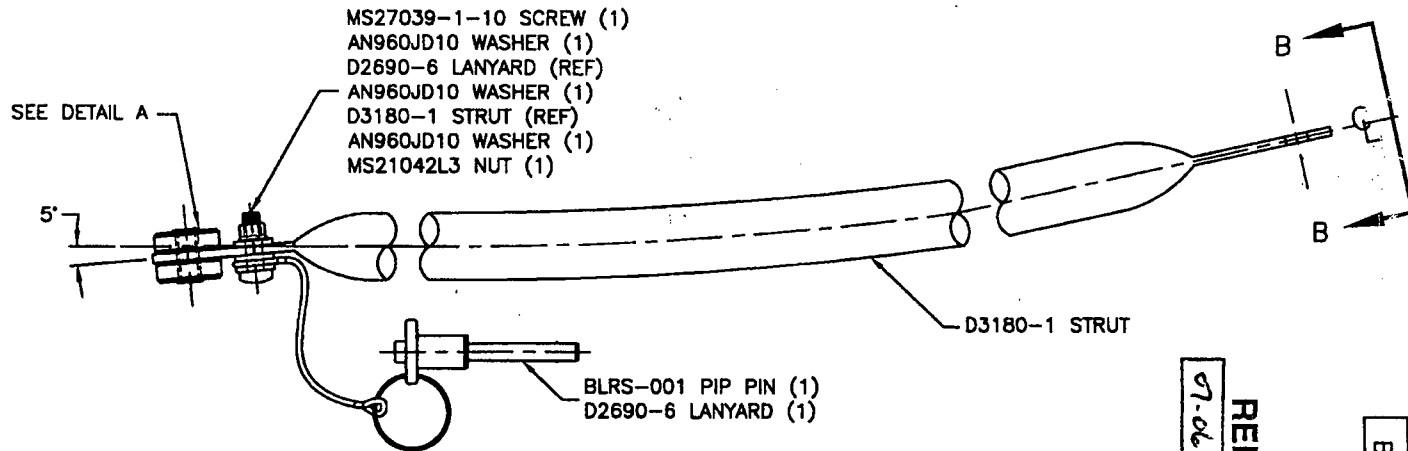
RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER

0. 32684
 BL 09-10-7

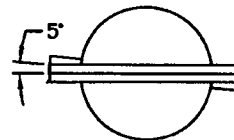
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>CE</i>	APPROVED <i>SC</i>	HAMKESBURY, ONTARIO, CANADA
DATE 07.05.23		REV. B
		SHEET 1 OF 2
		SCALE 1:2
		TITLE
		STRUT ASSEMBLY
		NEW ISSUE
		CURVE ADDED

RELEASED
 9.6.08

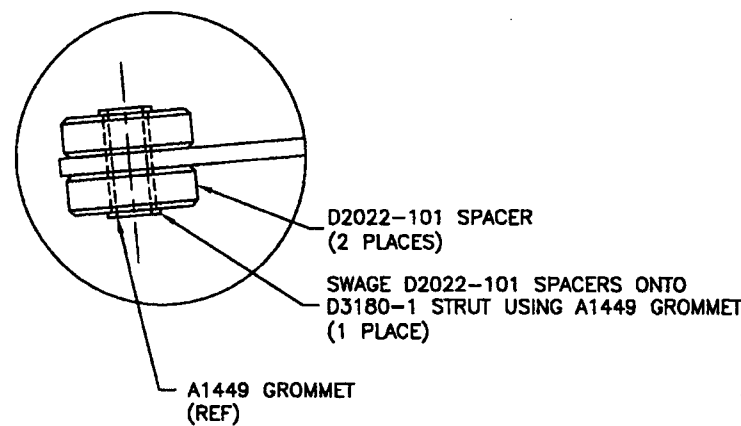


D3180-041 STRUT ASSEMBLY



VIEW B-B
 SCALE 1:1

QTY	PART NUMBER	DESCRIPTION
X	D3180-041	STRUT ASSEMBLY
1	D3180-1	STRUT
1	D2690-6	LANYARD
2	D2022-101	SPACERS
3	AN960JD10	WASHER
1	MS27039-1-10	SCREW
1	BLRS-001	PIP PIN
1	MS21042L3	NUT
1	A1449	GROMMET

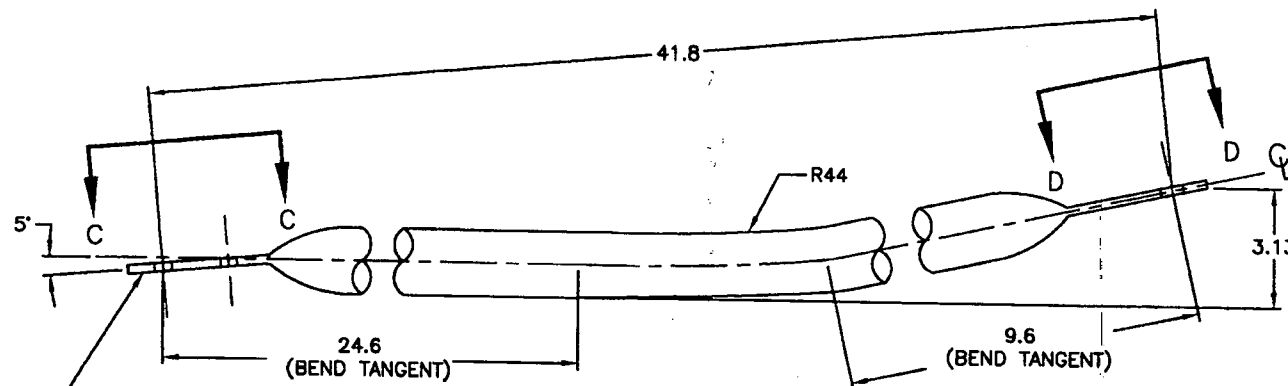


DETAIL A
 SCALE 1:1

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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED CO
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 526841
09-10-7
R

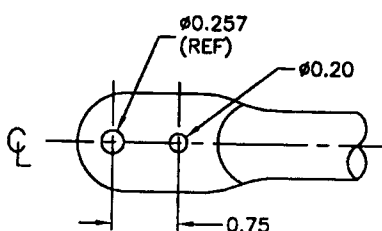
DART



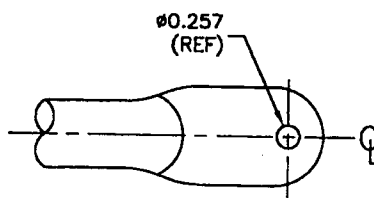
D3180-1 STRUT

USE PUNCH DT8117
BOTH ENDS
(DIMS PER SPEC. CONTROL DWG D2638)

RELEASED
07.06.08



VIEW C-C



VIEW D-D

NOTES

- 1) MATERIAL: AISI 304/316/318 SS TUBE,
Ø0.75 X 0.065 WALL
(REF. DART SPEC M304TRO.750W.065)
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART
QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH PART P/N "D3180-041" USING
FINE POINT PERMANENT INK MARKER

DESIGN	APPROVED	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	DRAWING NO.	HAWKESBURY, ONTARIO, CANADA
DATE		TITLE	REV. B
07.05.23		STRUT ASSEMBLY	SHEET 2 OF 2
			SCALE
			1:2